

Date: Thursday, 12/14/2006 3:46:22 PM  
 User: Kim Johnston

## Process Sheet

Customer / Job Number Estimate Number P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Checked & Approved By Comment	: CU-DAR001 Dart Helicopters Services : 29978B : 10378 : N/A : 12/14/2006 S.O. No. : N/A : NC : N/A Type : SMALL /MED FAB : 28939B	Drawing Name Part Number Drawing Number Project Number Drawing Revision Material Due Date	: STEP SPACER : D30653 : D3065 REV. B : N/A : B : N/A : 1/12/2007
		Qty:	60 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet 
		Comment: Qty: 0.2287 sf(s)/Unit Total: 13.7214 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: M102448 ML 06 12 19 (60)
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: B Prog Rev: B ML 06 12 19 (60)
		2-Deburr if necessary SAF 06/12/22 60
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE ML 06 12 19 (60)
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK ML 06/12/22 (60)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack SAF 06/12/22 (60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-3 PAR #: N/A Fault Category: Prod / Fab. Ass' <sup>med & Smt</sup> NCR Yes No DQA:  Date: 07.02.13  
QA: N/C Closed:  Date: 07.02.14

NCR: 29978B		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/20	3.0	All parts are scrap due to wrong thickness of material (Qty 60)		destroy & replace Make sure its the right thickness .040"	ML 06/12/20	 06/12/20	 06/12/20	 06/12/20

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 3:46:22 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 29978B

Part Number: D30653

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D30653

SD 07/02/08 (60)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/07/12/08 (60)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML YL

07/02/12 (60)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11/21/08

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EBox 12/13 (60) Ce

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



11/07/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	29978 B
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065	Rev: B	Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

X First Article Prototype

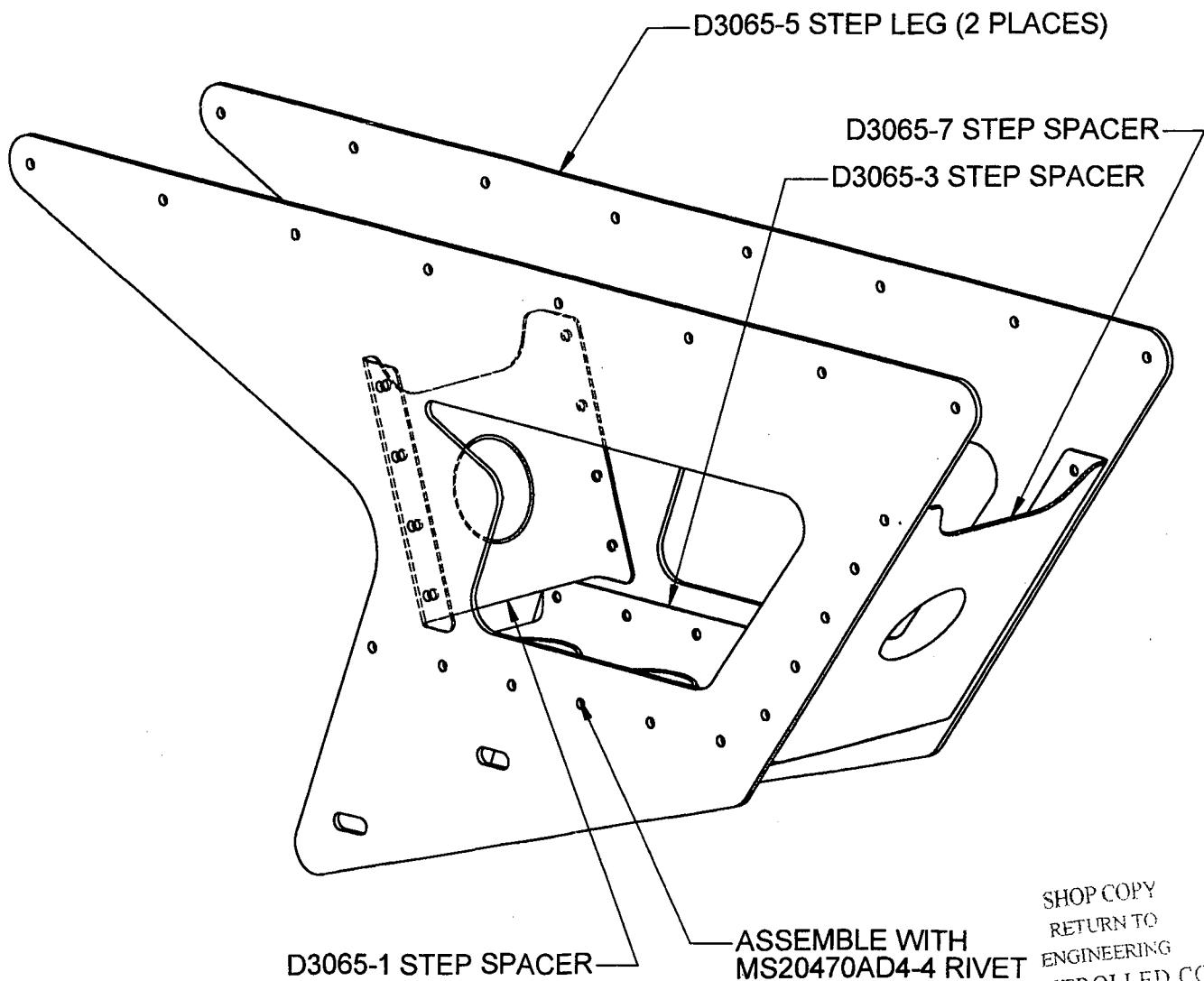
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1.264	✓		vern	
3.260	+/-0.010	3.265	✓		VERN	
5.260	+/-0.010	5.262	✓		VERN	
6.520	+/-0.010	6.520	✓		VERN	
2.093	+/-0.010	2.103	✓		VERN	
3.936	+/-0.010	3.944	✓		VERN	
4.186	+/-0.010	4.175	✓		VERN	
Ø0.128	+0.005/-0.000	0.128	✓		VERN	
Ø1.250	+0.005/-0.000	Ø1.250	✓		VERN	
Pitch 1.204	+/-0.005	1.205	✓		VERN	

<b>Measured by:</b>	<b>Audited by:</b>	<b>Prototype Approval:</b>
<b>Date:</b> 08 XZ FT	<b>Date:</b>	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	JL/J

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B	SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2	
A	02.09.11	NEW ISSUE		
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

**RELEASED**06.06.20 *[Signature]***D3065-041 STEP LEG ASSEMBLY**

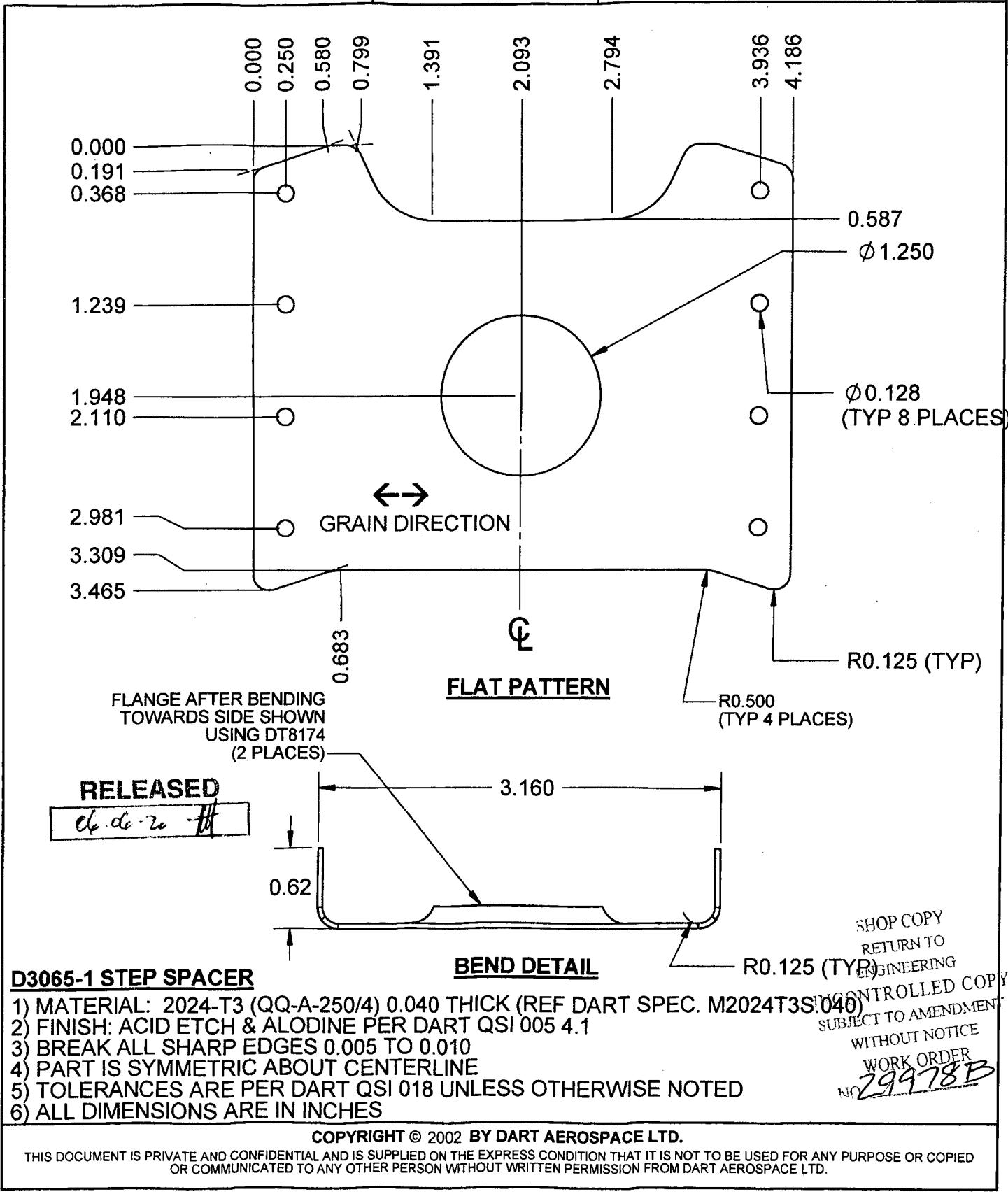
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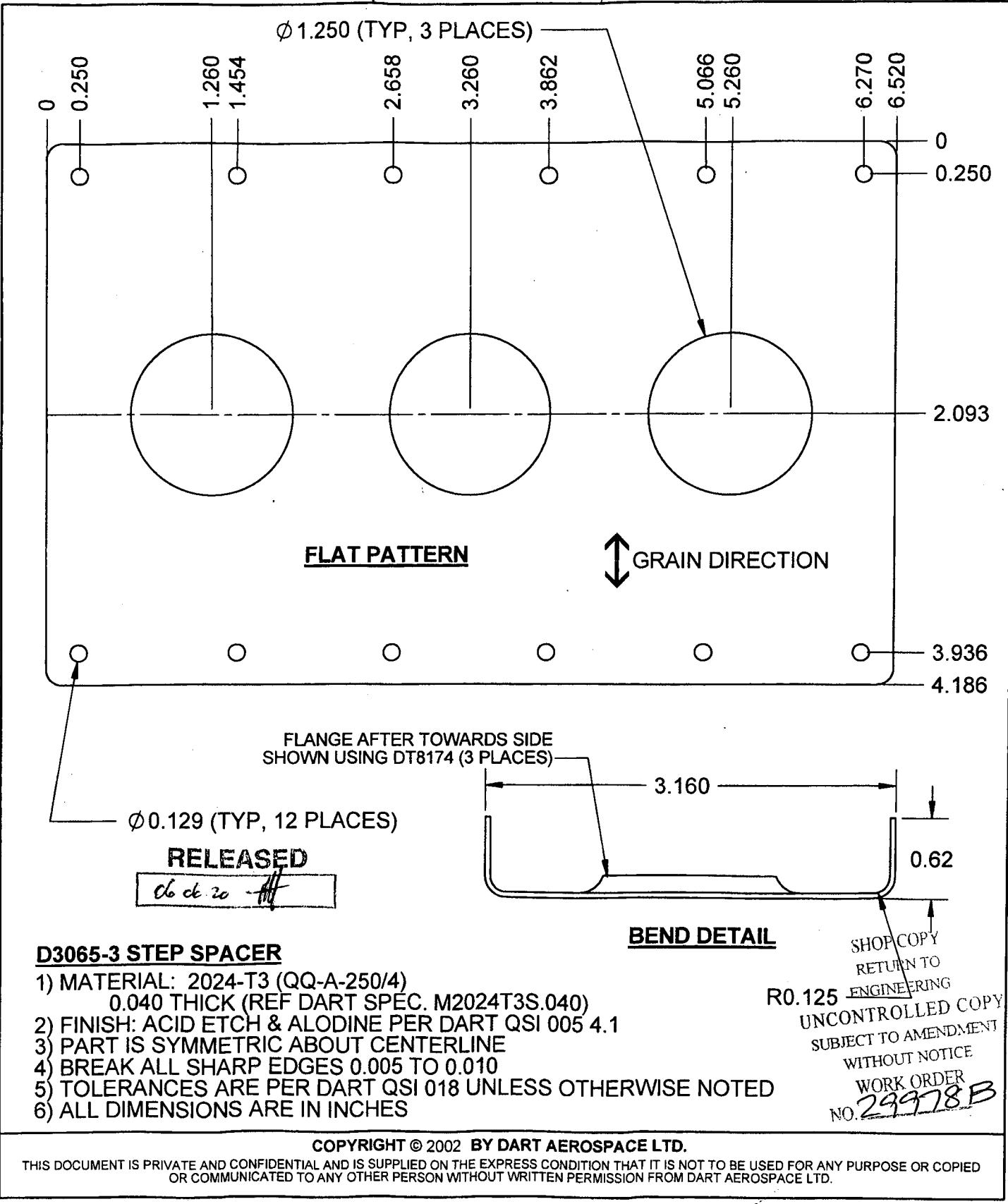
**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B	SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1	



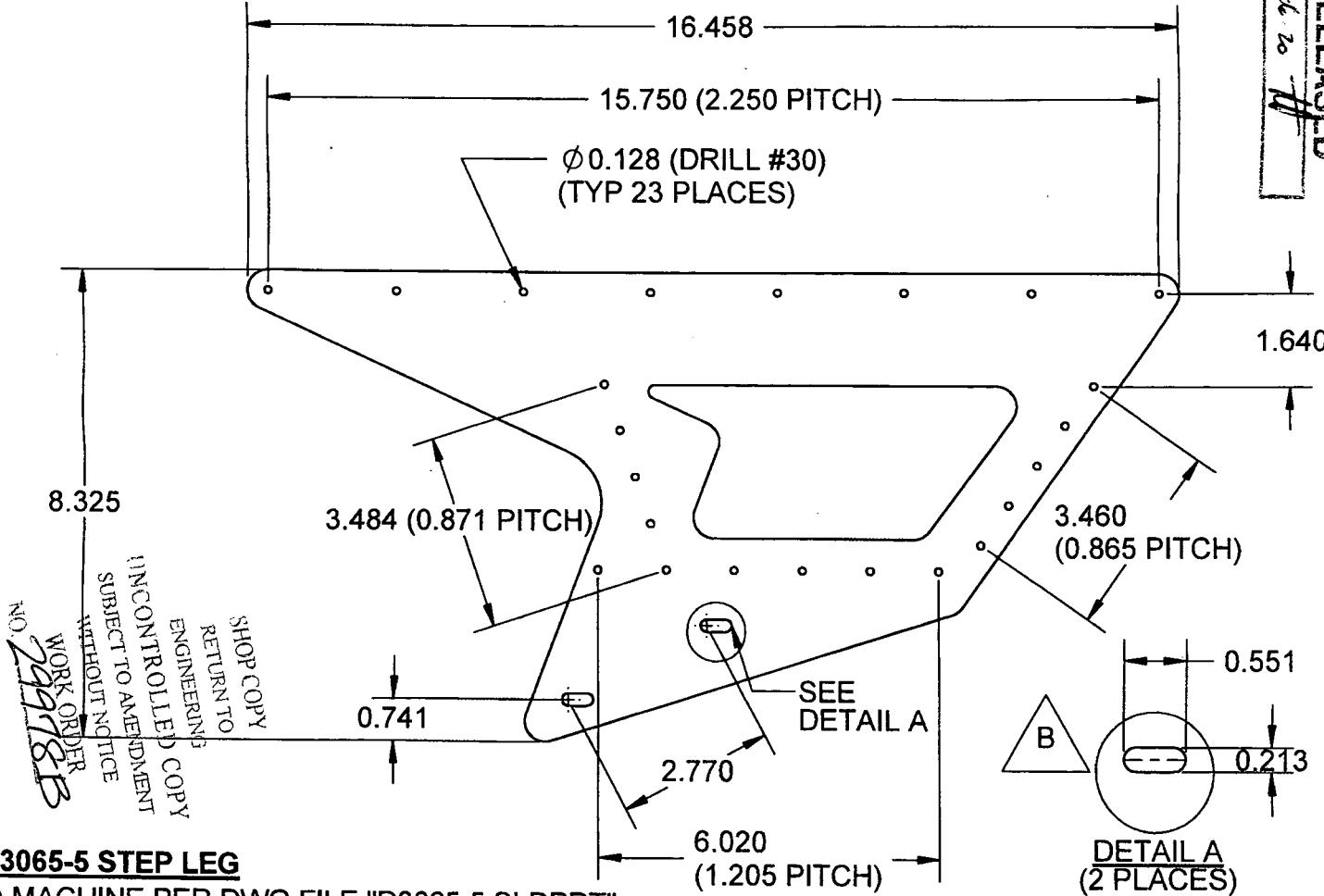
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CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3065</b>	REV. B	SHEET 3 OF 5
DATE 06.05.23		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1	



**DART**

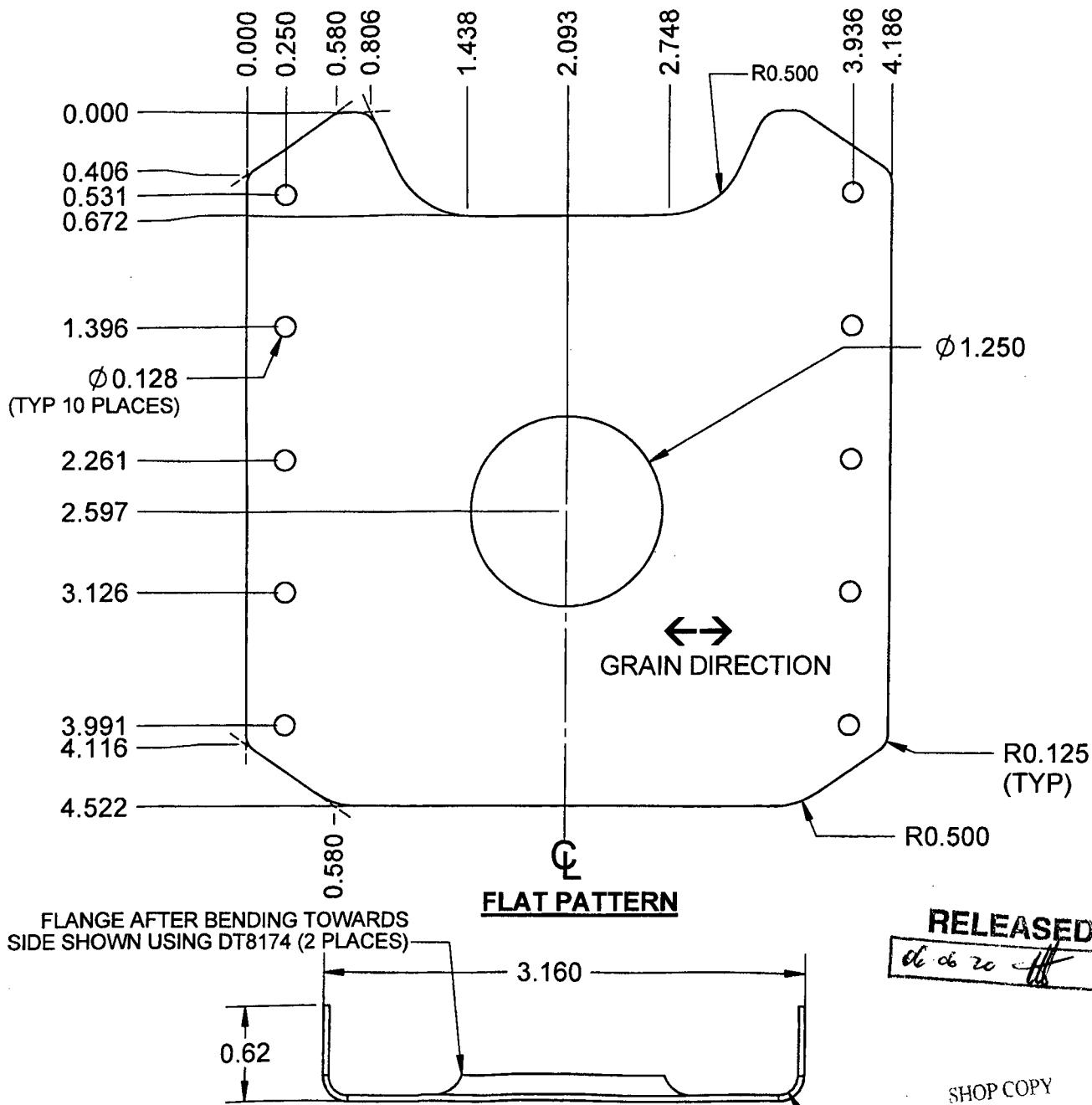
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CHECKED	APPROVED	DRAWING NO. D3065
DATE	06.05.23	TITLE STEP LEG ASSEMBLY

RELEASED  
06.06.20**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	29978B
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065 , Rev: B		Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article X Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>M</u>	Prototype Approval:	
Date:	06/12/20	Date:	<u>06/12/20</u>	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	